

**Work Order ID 60245**

Page 1

Tuesday, June 29, 2010 3:47:36 PM

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start

Approvals: Process Plan: PL Date: 10-6-29 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-512 CHG004

S. Wolzke

(P10)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-7-2 @ JP

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
100707	W/O Dwg handle	FIN is now @ Rev N. update Rev. M → N. perm. change		10.07.07				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

**Work Order ID 60245**

Page 2

Tuesday, June 29, 2010 3:47:36 PM

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 6/29/06

②

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-512 Location: \_\_\_\_\_

NVA

Cup 7/6 ②

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

P. 10-7-5

MF  
10-7-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 3:47:40 PM

Page 2 1/10

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

AN4C6A

Purchased

No

110

Each

487.0000

12 24



Bolt

## Location

## Loc Qty

## Loc Code

FG

4

103344

4

ST356

483

113121

283

115016

200

24

AN5C11A

Purchased

No

110

Each

260.0000

8 16



Bolt

## Location

## Loc Qty

## Loc Code

FG

4

104817

4

ST338

256

112933

16

114443

70

114455

70

114523

100

16

AN5C12A

Purchased

No

110

Each

100.0000

4 8



Bolt

## Location

## Loc Qty

## Loc Code

FG

2

18918

2

ST338

98

113121

98

8

Tuesday, June 29, 2010 3:47:40 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, June 29, 2010 3:47:40 PM

Page 3 / 10

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

AN5C13A

Purchased No

110 Each

113.0000



4 18

10.7.28

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

111

111648

11

113121

50

114615

50

AN5C15A

Purchased No

110 Each

96.0000



1 2

10.7.28

Location

Loc Qty

Loc Code

ST339

96

111819

96

AN5C32A

Purchased No

110 Each

105.0000



2 4

10.7.28

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

101

110155

10

111808

41

113164

50

Tuesday, June 29, 2010 3:47:40 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 3:47:40 PM

Page 4 / 10

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

5 12 AN5C34A

Purchased No

110 Each

118.0000



2 4  
10-7-28

## Location

## Loc Qty

## Loc Code

FG

2

18918

2

ST340

116

110342

6

111648

50

112454

60

5 12 AN5C35A

Purchased No

110 Each

100.0000



2  
10-7-28

## Location

## Loc Qty

## Loc Code

ST340

100

107551

2

108084

50

108407

48

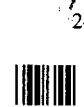
AN960C10L

NAS1149C0332  
R

Purchased No

110 Each

0.0000



24 48

5 12 washer

1115000 10-7-28

Tuesday, June 29, 2010 3:47:40 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 3:47:40 PM

Page 5 / 10

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

AN960C416L

Purchased No

110 Each

972.0000



WASHER



24 48 2K  
M112612 10-7-25

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

928

106785

38

107008

10

112794

439

112828

400

69220

41

AN960C516L

NAS1149C0532  
R

Purchased No

110 Each

14.0000



WASHER



8 16  
10-7-25 sf

Location

Loc Qty

Loc Code

ST347

14

111916

14

D206-648-013

Manufactured No

110 Each

0.0000



GHW Modification

CHG7002



2  
B 59234 10-7-25

D2652

Manufactured No

110 Each

379.0000



Bushing



16 32  
10-7-25 sf (2K)

Location

Loc Qty

Loc Code

FG

44

31985

44

ST021

335

58176

122

59109

213

32

Tuesday, June 29, 2010 3:47:41 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 3:47:41 PM

Page 6 / 10

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

D2712

Manufactured No

110

Each

223.0000

10 20



Set Screw

## Location

## Loc Qty

## Loc Code

FG

50

29962

50

ST022

173

16400

20

50415

153

D2932-2

Manufactured No

110

Each

9.0000

1 2



Saddle RH Out, 206

## Location

## Loc Qty

## Loc Code

ST421

3

53329

3

ST428

6

58266

6

D2933-2

Manufactured No

110

Each

7.0000

1 2



Saddle RH In, 206

## Location

## Loc Qty

## Loc Code

ST428

7

52587

4

53330

3

Tuesday, June 29, 2010 3:47:41 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, June 29, 2010 3:47:41 PM

Page 7 *110*

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

D2934

Manufactured No

110

Each

76.0000



Saddle Spacer

2 1 4  
10-7-2 SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST031

70

50376

2

59641

68

D2935

Manufactured No

110

Each

62.0000



Saddle Spacer

2 1 4  
10-7-2 SP

Location

Loc Qty

Loc Code

ST028

45

59642

45

ST031

17

50211

17

D2938-2

Manufactured No

110

Each

10.0000



Saddle RH Out, 206

2 4  
10-7-2 SP @

Location

Loc Qty

Loc Code

ST421

3

53332

3

ST428A

2

58269

3

58533

4

-2

Tuesday, June 29, 2010 3:47:41 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 3:47:41 PM

Page 8

110

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

D2939-2

Manufactured No

110

Each

9.0000

1 2



Saddle RH In, 206

S  
+2

Location

Loc Qty

Loc Code

ST428A

9

53334

3

58268

2

58535

4

10-7-25

D3396-3

Manufactured No

110

Each

47.0000

2 4



Spacer

S  
2

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

37

58680

37

10-7-25

D3407-043

Manufactured No

110

Each

41.0000

1 2



Tow Ring

S  
2

Location

Loc Qty

Loc Code

ST464

41

50176

9

50387

20

53351

12

10-7-25

D3456-1

Manufactured No

110

Each

69.0000

1 2



Washer

S  
2

Location

Loc Qty

Loc Code

ST058

69

54692

69

10-7-25

Tuesday, June 29, 2010 3:47:41 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 3:47:41 PM

Page 9 110

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

D3457-1

Manufactured No

110 Each

69.0000



Washer

24

14



10.7-2sf

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

59

45913

8

52981

51

4

D3672-1

Manufactured No

110 Each

1,159.000



Phenolic Washer

24

148



10.7-2sf

Location

Loc Qty

Loc Code

ST077

1159

51674

159

52505

1000

48

D3672-3

Manufactured No

110 Each

902.0000



Phenolic Washer

24

148



10.7-2sf

Location

Loc Qty

Loc Code

ST077

902

57704

902

48

D3672-7

Manufactured No

110 Each

748.0000



Phenolic Washer

24

148



10.7-2sf (20)

Location

Loc Qty

Loc Code

ST077

748

53237

748

48

Tuesday, June 29, 2010 3:47:41 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 3:47:41 PM

Page 10 / 10

Work Order ID: 60245

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

3,149.000

20 / 40



Sa  
Nut



10-7-2 sf

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

3073

112314

3073

MS21043-4

Purchased

No

110

Each

1,352.000

13 / 26



Sa  
Nut



10-7-2 sf

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1312

112492

25

113069

8

~~114348~~

479

114523

500

114784

300

MS21043-5

Purchased

No

110

Each

624.0000

4 / 8



Sa  
Nut



10-7-2 sf (2x)

Location

Loc Qty

Loc Code

ST301

624

111819

124

112314

500

Tuesday, June 29, 2010 3:47:41 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			AN3C4A	* BOLT <sup>(1)</sup>
5A			2			AN960C10L	* WASHER <sup>(1)</sup>
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4				AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET <sup>(1)</sup>
23A			1	1		D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET <sup>(1)</sup>
24A			1	1		D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET <sup>(1)</sup>
25A			1	1		D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET <sup>(1)</sup>
26A			78	78		AN3C4A	* BOLT <sup>(1)</sup>
26B			78	78		AN960C10L	* WASHER <sup>(1)</sup>
26C			78			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

continued on next page...

© COPYRIGHT © 2000 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: N  
Date: 09.09.09

REFERENCE ONLY

DART AEROSPACE USA, INC.

D206-642  
Page 26 of 34

continued from previous page...

ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE  
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

• COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: N  
Date: 09.09.09

**Work Order ID 60245**

Tuesday, June 29, 2010 3:47:36 PM



Page 1

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*Handwritten signature*

Date: 10-6-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-512 CHG004

*Handwritten: 10-7-05*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*Handwritten: 10-7-2*

REFERENCE ONLY